

WHAT IS CLAIMED IS:

1. A method for producing a monolayer polymeric film having improved strength and stiffness in the machine direction and in the transverse direction, the method comprising the steps of:
  - 5 a. combining a primary polymeric structural material and a secondary polymeric material together to form a unitary mixture thereof;
  - b. directing said unitary mixture to extrusion means to create an extruded unitary mixture; and
  - c. directing said extruded unitary mixture to a plurality of stretching rollers for stretching of said extruded unitary mixture, wherein said plurality of stretching rollers includes one or more heat-stabilization rollers operated at a temperature sufficient to impart substantial stiffness and substantial flatness to said extruded unitary mixture without delamination and while controlling film curling.
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- 15 2. The method as claimed in **Claim 1** wherein said one or more heat-stabilization rollers operates at a temperature of about 270° F.
3. The method as claimed in **Claim 2** wherein said one or more heat-stabilization rollers have a high-chrome finish of less than eight RMS.
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4. The method as claimed in **Claim 1** wherein the step of directing said extruded unitary mixture to a plurality of stretching rollers includes the steps of:
  - 25 a. directing said extruded unitary mixture to a first casting chiller roller;
  - b. directing said extruded unitary mixture to a second casting chiller roller;
  - c. directing said extruded unitary mixture to a pair of pre-heater rollers;
  - d. directing said extruded unitary mixture to a plurality of stretching and orientation rollers; and
  - 30 e. directing said extruded unitary mixture to a first heat-stabilization roller and a second heat-stabilization roller of said one or more heat-stabilization rollers, wherein said first heat-stabilization roller and

said second heat-stabilization roller have independent driver controllers.

5. The method as claimed in **Claim 4** wherein said first heat-stabilization  
5 roller and said second heat-stabilization roller are at an operating temperature of  
about 270° F to about 295° F.

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6. The method as claimed in **Claim 5** wherein said primary polymeric  
structural material is polypropylene.

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7. The method as claimed in **Claim 6** wherein said secondary polymeric  
material is vinyl-acetate.

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8. The method as claimed in **Claim 7** wherein said vinyl-acetate is provided in  
an ethylene-vinyl-acetate copolymer.

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9. The method as claimed in **Claim 6** wherein said secondary polymeric  
material is methacrylate.

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10. The method as claimed in **Claim 5** wherein said primary polymeric  
structural material is polyethylene.

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11. The method as claimed in **Claim 10** wherein said secondary polymeric  
material is vinyl-acetate.

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12. The method as claimed in **Claim 11** wherein said vinyl-acetate is provided  
in an ethylene-vinyl-acetate copolymer.

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13. The method as claimed in **Claim 10** wherein said secondary polymeric  
material is methacrylate.

14. A polymeric film having flexibility and clarity, the film comprising a blend of a structural polymeric material and a clarity-enhancing material.

15. The polymeric film as claimed in **Claim 14** wherein said structural  
5 polymeric material is selected from the group consisting of polyethylene and polypropylene.

16. The polymeric film as claimed in **Claim 15** wherein said clarity enhancing material is styrene-ethylene-butadiene-styrene (SEB-S).

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17. The polymeric film as claimed in **Claim 16** wherein said SEB-S is about 10% by weight of said blend.

18. The polymeric film as claimed in **Claim 16** wherein said blend further  
15 includes a coloring additive.

19. The polymeric film as claimed in **Claim 16** wherein said blend further includes a printable material additive.

20 20. The polymeric film as claimed in **Claim 19** wherein said printable material additive is selected from the group consisting of vinyl-acetate and methylmethacrylate.

21. A shampoo bottle including a pliable film, the pliable film comprising a  
25 blend of polypropylene and styrene-ethylene-butadiene-styrene.

22. An envelope having two or more layers spaced from one another to form a pocket therebetween, wherein at least one of said two or more layers is formed of a pliable film, the pliable film comprising a blend of polypropylene and styrene-  
30 ethylene-butadiene-styrene.